

Date: Tuesday, 8/22/2006 4:15:17 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI UTILITY BASKET LH/RH
Job Number	: 28297		
Estimate Number	: 10197		
P.O. Number	: <i>N/A</i>	Part Number	: D350607041
This Issue	: 8/22/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D350-607 REV F P7-9
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: F
Previous Run	: 28039	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 8/29/2006 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature]</i> 06.08.23		
Comment	: Est Rev:M 05.09.02 Added D2856-400-720 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



(1)

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD350-607-041 CHG006

KS 06.08.29

2.0	28297A	BASKET BASE ASSEMBLY (350)
-----	--------	----------------------------



Comment: Sub-Component BASKET BASE ASSEMBLY (350)

D2221 B *28297A* ✓

3.0	28297B	350/212/130 BASKET LID
-----	--------	------------------------



Comment: Sub-Component 350/212/130 BASKET LID

D2512 B *28297B* ✓

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

5.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	D2022-101	Spacer	<i>B 25815</i>

m.f. 06/10/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/22/2006 4:15:17 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 28297

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2258200

Weight Placard 200lb



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D2258-200

Label B 28312

mf. 06/10/30

7.0

D2332041

Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D2332-041

Prop Ass'y B 28246

mf. 06/10/30

8.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D2530

Handle Weldment B 28247

mf. 06/10/30

9.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2535

Spring B 25087

mf. 06/10/30

10.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2537

Bushing B 28327

mf. 06/10/30

11.0

D27283

Dart Logo label large



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2728-3

Label B 22553

mf. 06/10/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 28297

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2931

Bumper

B21139

MF. 06/10/30

13.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt

M101884

MF. 06/10/30

14.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-7A

Bolt

M106827

MF. 06/10/30

15.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-22A

Bolt

M17280

MF. 06/10/30

16.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-24A

Bolt

M17204

MF. 06/10/30

17.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt

M01537

MF. 06/10/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 28297

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD8 Washer m11989

MF. 06/10/30

19.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416 Washer m102339

MF. 06/10/30

20.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416L Washer m101237

MF. 06/10/30

21.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer m102328

MF. 06/10/30

22.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer m100151

MF. 06/10/30

23.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS20600AD4W3 Rivet m101519

MF. 06/10/30

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 28297

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) m101390

MF 06/10/30

25.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) m19099

MF 06/10/30

26.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5) m101648

MF 06/10/30

27.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D350-607

Seal support gusset seam with white sikaflex-291 Batch: m102107

Expiry date: 02/2007

MF - 06/10/30 (1)

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/10/30 (1)

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/22/2006 4:15:18 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 28297

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D22301

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-1

Lug

B28281 ✓

31.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-3

Clamp

B28245 ✓

32.0

D23241

Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 *D2324-1

Strut Ass'y

B28062 ✓

33.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 0.6000 f(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2856-400-720 Abrasion Strip

B28258 ✓

NO UNITS allocated in the computer system

34.0

AN412A

Bolt



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

5 AN4-12A

Bolt

M102029 ✓

35.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN4-13A

Bolt

M101938 ✓

P306/10/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/22/2006 4:15:18 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 28297

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

AN960JD416

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

26 AN960JD416

Washer

1102339 ✓

37.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4)

119099

LB 06/10/30 ①

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

CL 06/10/30 ①

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-607-041

Location: _____

REV G

LB 06/10/30 ①

40.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

LB 06/10/31 ①

Job Completion



W 06-10-31

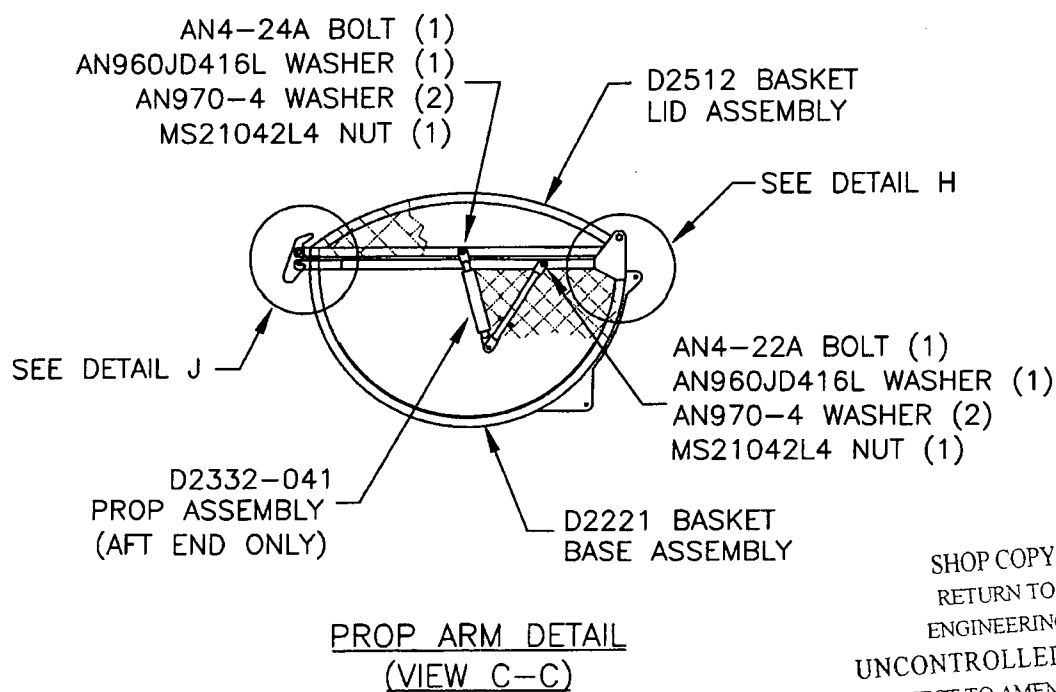
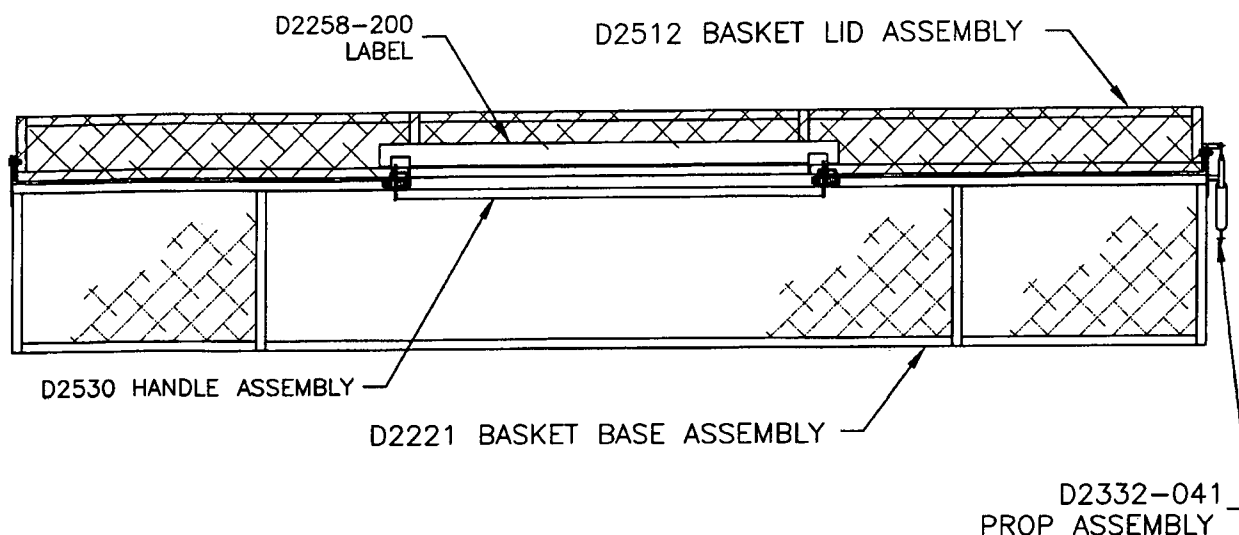
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



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WORK ORDER
NO. 28297

Figure 4 - Basket Replacement Parts
(D350-607-041 Heli-Utility-Basket™)

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Revision: **F**
Date: 03.01.17

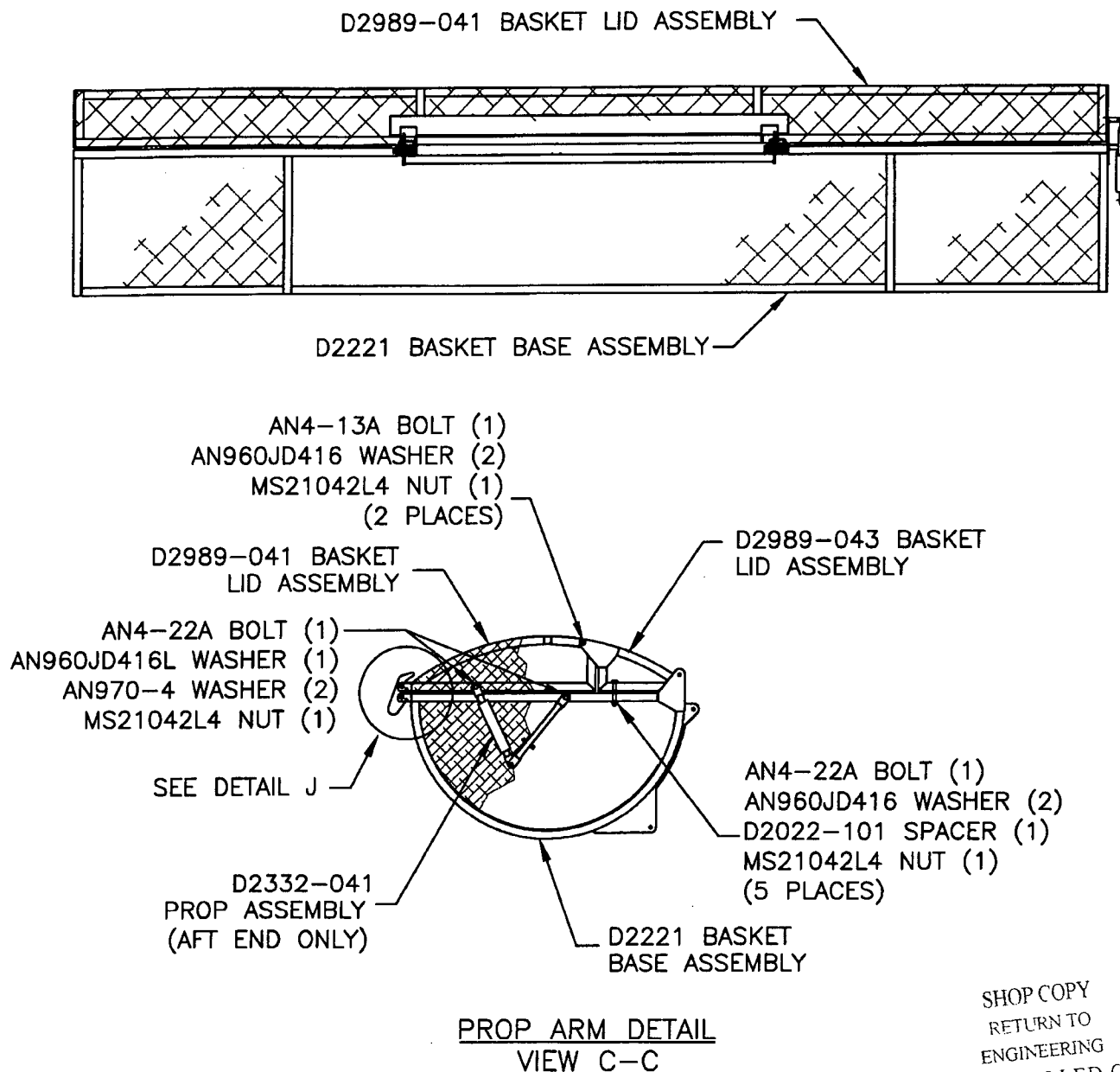
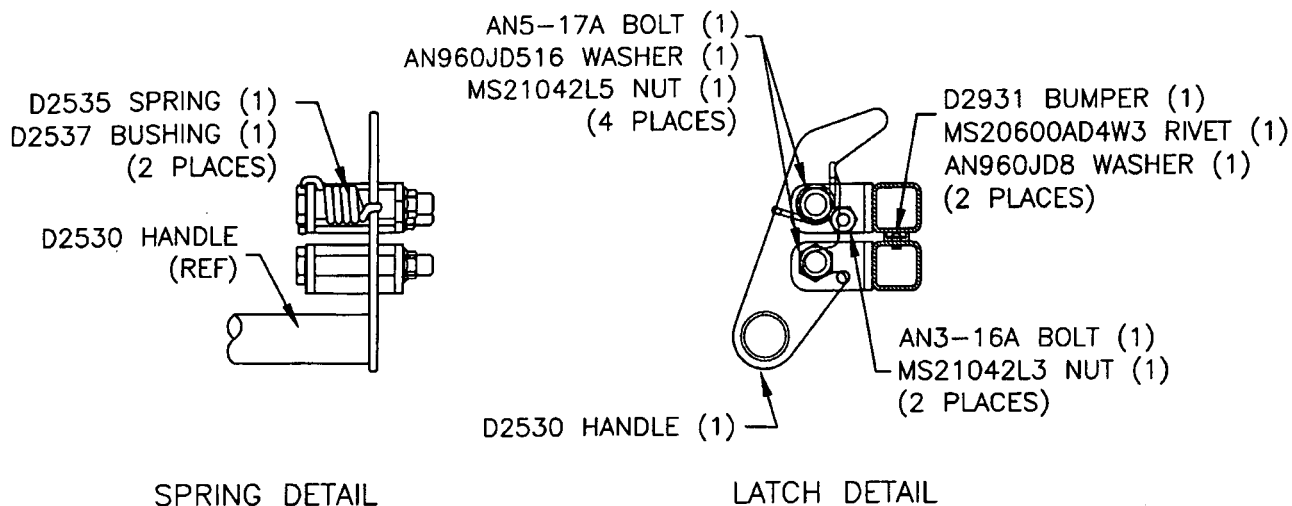


Figure 5- Basket Replacement Parts
(D350-607-043 Heli-Utility-Basket™)

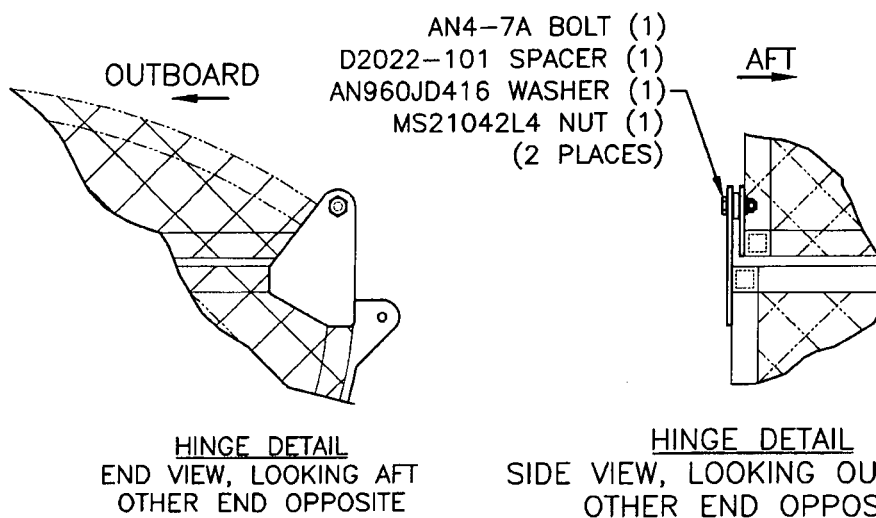
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WORK ORDER
NO. 28297

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Revision: **F**
Date: 03.01.17



DETAIL J:
HANDLE WELDMENT



DETAIL H:
HINGE

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WORK ORDER
NO. 28297

Figure 6 – Basket Replacement Parts



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSI 9318	REV. A SHEET 1 OF 1
DATE 06.01.06		TITLE WASHER ADDITION	SCALE NTS
A	06.01.06	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607 REV. F

REF. CANADIAN STC: SH94-14 ISSUE 4

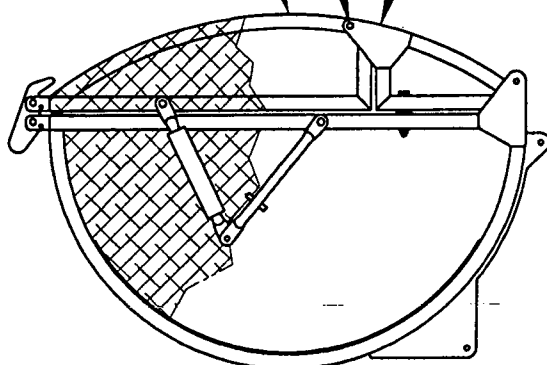
REF. FAA STC: SR00213NY

To reduce the possibility of damaging the finish, a **NAS1515H4** washer (2 places) has been added between the hinge plate and basket frame on the **D350-607-043/-047 Heli-Utility-Basket**.

The corrected bolt stackup from Figure 5 of installation instructions D350-607 Rev. F is given below:

AN4-13A BOLT (1)
AN960JD416 WASHER (1)
HINGE PLATE (REF)
NAS1515H4 WASHER (1)
BASKET FRAME (REF)
AN960JD416 WASHER (1)
MS21042L4 NUT (1)
(2 PLACES)

BASKET FRAME (REF) HINGE PLATE (REF)



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WITHOUT NOTICE
WORK ORDER
NO. 28297

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED BY: [Signature] D. SHEPHERD (DE #02)	
DATE:	06.01.06
CERT. NO.:	SH94-14
ISSUE NO.:	4

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NO. 19

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Carl Laviolette

Joint Welding Procedure Tig

Part number and Job number D222 / B28277

D350 607 041

TEST WELDS REQUIRED

BASE METAL S.S.

WELDING PROCESS Tig

Penetration Complete ☒ Partial ☐

Single Weld ☒ Double Weld ☐

Current AC ☐ DC ☒

Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐

Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☐ Fail ☐

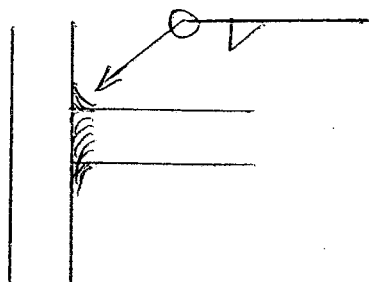
The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/02

Qualifier David Kewel

Weld Base Assn (BSA) (ASBQV)

- Weld 304 3/4" x 3/4" x 0.065" S.S. Tube



Date: Tuesday, 8/22/2006 4:15:37 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASSEMBLY (350)
Job Number	: 28297A		
Estimate Number	: 10189	Part Number	: D2221
P.O. Number	: N/A	Drawing Number	: D2221/D2235
This Issue	: 8/22/2006 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: F/B1
First Issue	: N/A Type : LARGE FAB ASSY	Material	: N/A
Previous Run	: 28294C	Due Date	: 8/29/2006 Qty: 1 Um: Each
Written By	:		
Checked & Approved By	: <u>06-08-23</u>		
Comment	: Est Rev:J 05.09.02 Added D3442-1KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31661	Basket Hoop
-----	--------	-------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D3166-1	RIB	<u>328094</u>

Cpl 06-10-03

2.0	D22323	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-3	Hinge bracket	<u>324527</u>

Cpl 06-10-03

3.0	D2325	Support Gusset (350 Bask
-----	-------	--------------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D2325	Support Gusset	<u>328313</u>

Cpl 06-10-03

4.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2327-3	Bushing	<u>328073</u>

Cpl 06-10-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/22/2006 4:15:37 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 28297A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket

B27587

RPL 06.10.03

6.0

D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim

B26739

RPL 06.10.03

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)

Pick:

Qty Part Number Description Batch

36 sf M304EX0.75-16F Expanded Metal

M102126

RPL 06.10.04

8.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M102040 → 29.4000

RPL 06.09.22

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

RPL 06.10.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/01/31

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/22/2006 4:15:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 28297A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

06/10/23

11.0

POWDER COATING

POWDER COATING



M101575



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

yl

06/10/26 x 1

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf. 06/10/30 ①

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/10/31 ①

Job Completion



06.10.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

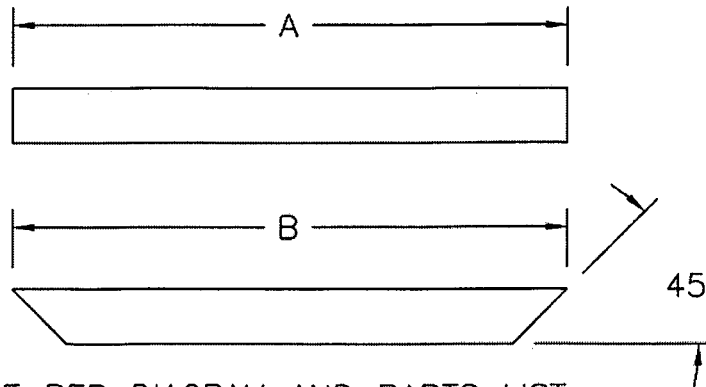
QA: N/C Closed: _____ Date: _____

DART

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
C	95.11.21	SEPARATE BASKET AND LID	
D	96.06.21	CHANGE LATCH	
E	01.04.19	CHANGE HINGE	
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS	

RELEASED05.08.19 *[Signature]***PARTS LIST FOR D2221 BASKET BASE ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM

D2221-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
(REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL $\phi 0.257$ HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH
D2989-041/-043 BASKET LID

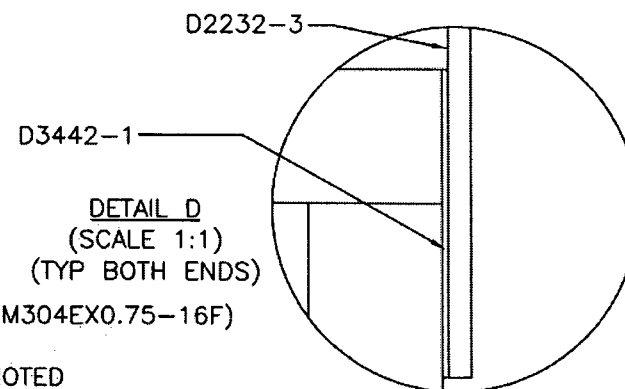
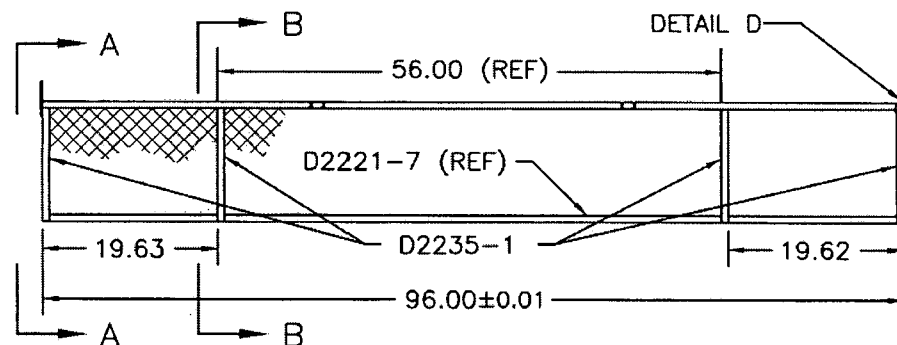
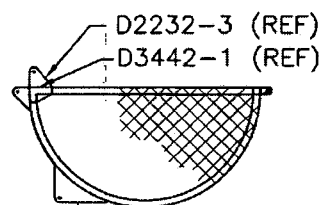
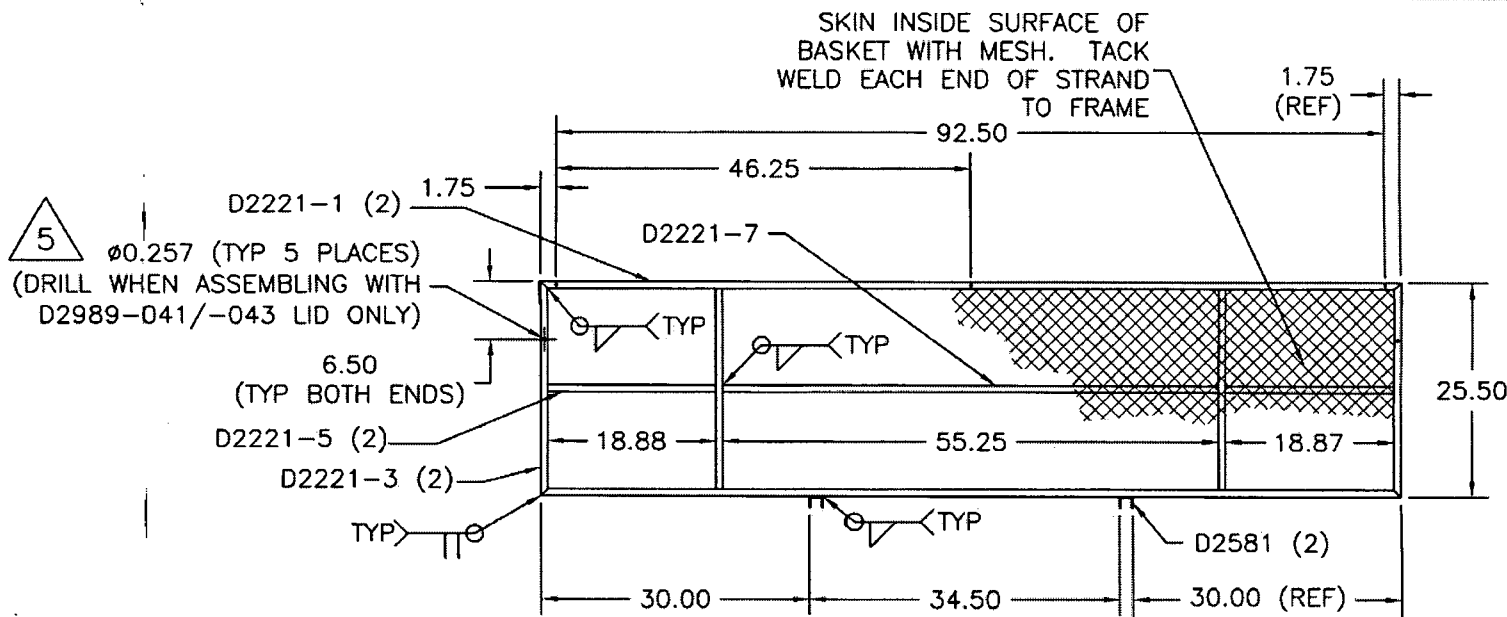
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NO. 28297 A

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DART

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HANKESBURY, ONTARIO, CANADA	
DATE	05.06.07	TITLE	D2221	BASKET BASE ASSEMBLY (350)	SHEET 2 OF 3
					SCALE 1:20



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NO. 28297A

WORK ORDER

28297A

D2325 (REF)

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RELEASED

05.08.19

D2221 BASKET BASE ASSEMBLY

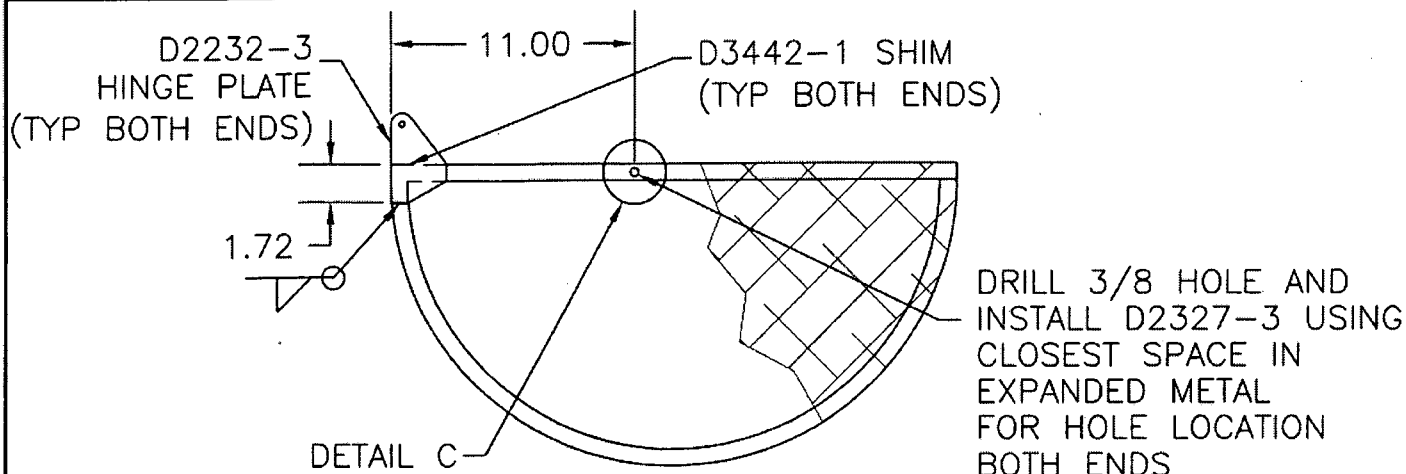
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

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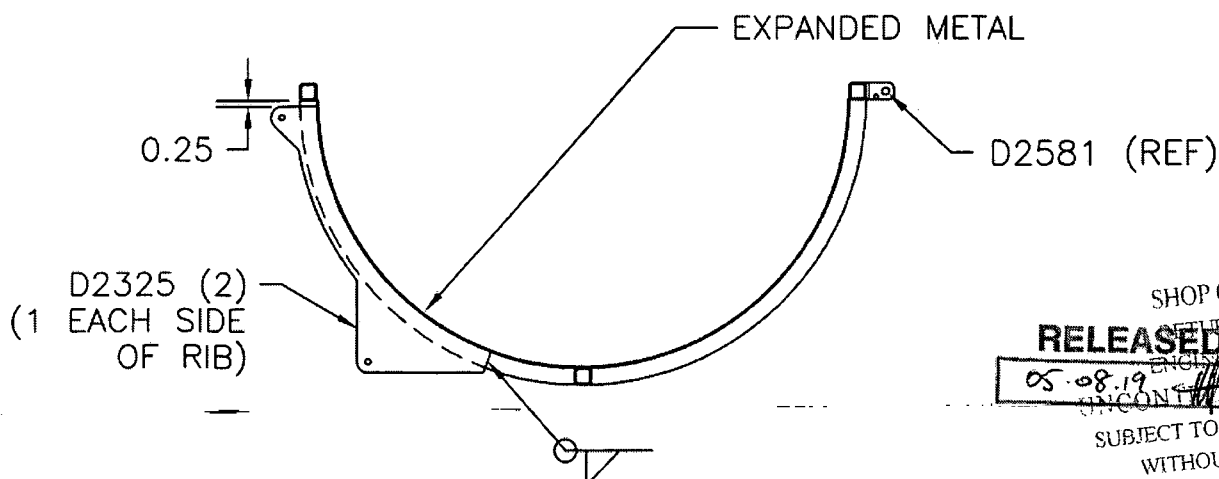
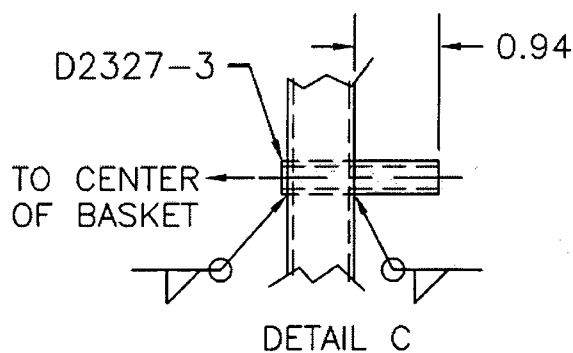
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DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8



SECTION A-A SAME BOTH END RIBS



SECTION B-B SAME BOTH CENTER RIBS

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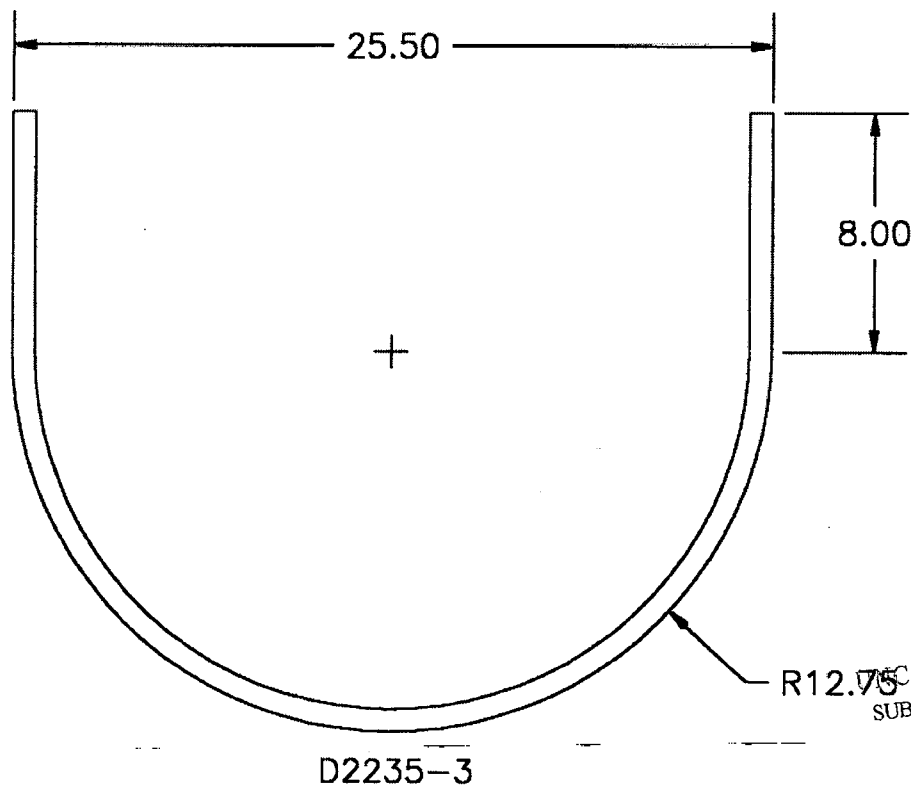
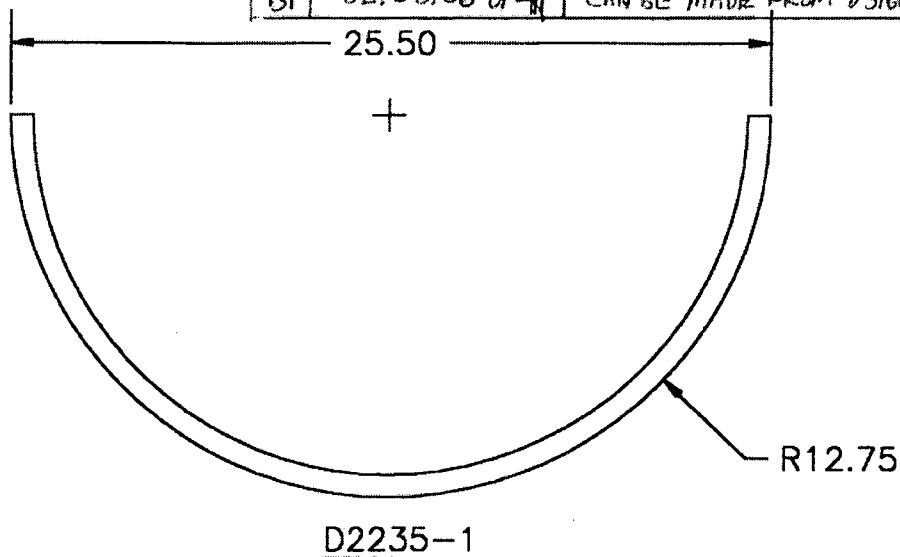
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DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED	APPROVED	D2235	SHEET 1 OF 1
DATE		TITLE	SCALE
94:12:16		BASKET RIBS	
BI	02.08.06	CAN BE MADE FROM D3166-1	

RELEASED
R 960507



CAN BE MADE FROM D3166-1 
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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WORK ORDER
NO. 28297A

Date: Tuesday, 8/22/2006 4:15:55 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350/212/130 BASKET LID
Job Number	: 28297B		
Estimate Number	: 10193		
P.O. Number	: <i>N/A</i>	Part Number	: D2512
This Issue	: 8/22/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2512 REV D2
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 28051A	Drawing Revision	: D2
	Type : LARGE FAB ASSY	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 8/29/2006
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



✓ Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .063" wall

Batch: *M102040* → *45.7594**CPL 06.09.22*

2.0	D31663	Basket Hoop
-----	--------	-------------



✓ Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3166-3 Basket Hoop

Batch

*B28525**CPL 06.09.29*

3.0	D2506	Placard
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2506 Label Plate

Batch

*B26631-2**CPL 06.09.29*

4.0	D23271	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D2327-1 Bushing

Batch

*B28334**CPL 06.09.29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/22/2006 4:15:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 28297B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

Hinge plate

~~B27524~~
B25238

CPL 06-09-BA29

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B27587

CPL 06-09-BA29

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf M304EX0.75-16F Expanded Metal

M102394

CPL 06-10-20

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

CPL 06-10-20

9.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

DA 06/10/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SD Date: 06/10/31

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/22/2006 4:15:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 28297B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

POWDER COATING

POWDER COATING



M101575



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

YL

06/10/26 x1

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



YL 06/10/27



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: M102098

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 06/10/30

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

JB 06/10/30

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/10/31

Job Completion



u 06-10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

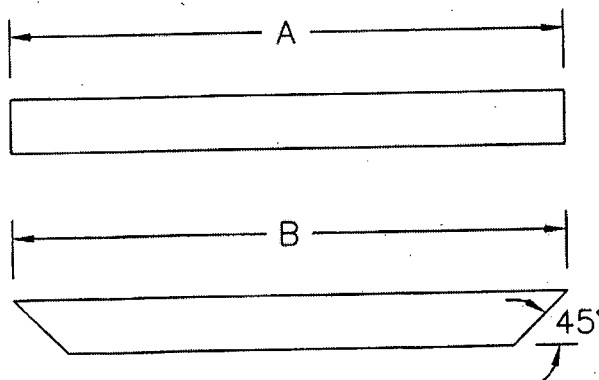


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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212) SCALE NTS	
A	95.11.21	NEW ISSUE	
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE	
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074	
D	01.04.19	CHANGE HINGE	
D1	<i># UP</i> 03.01.20	ADD D2012-117 FOR D130-701-041	
D2	<i># UP</i> 04.09.20	TACK WELD ANT-SKID AREA	

RELEASED
01.04.27 *#*

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



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D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS; 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

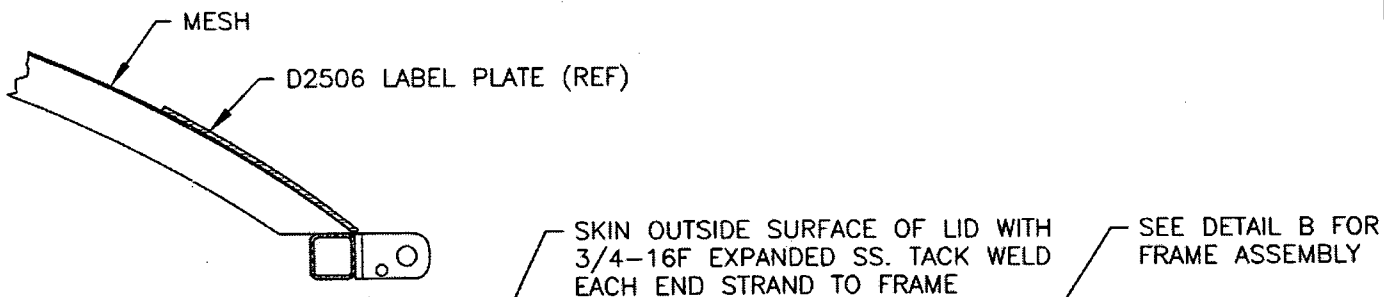
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2512
DATE	01.04.19	TITLE	BASKET LID ASSEMBLY (350/212)	REV. 0 SHEET 2 OF 4
		SCALE	1:20	

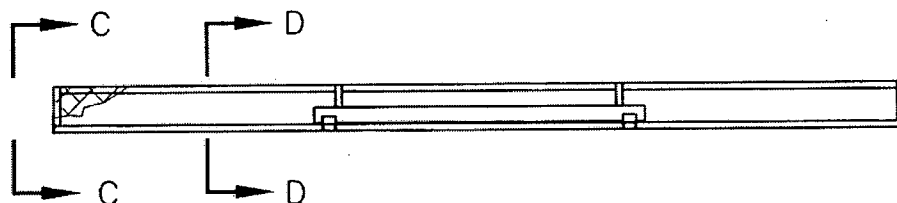


FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

D2 TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED

D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE



D2512 BASKET LID ASSEMBLY

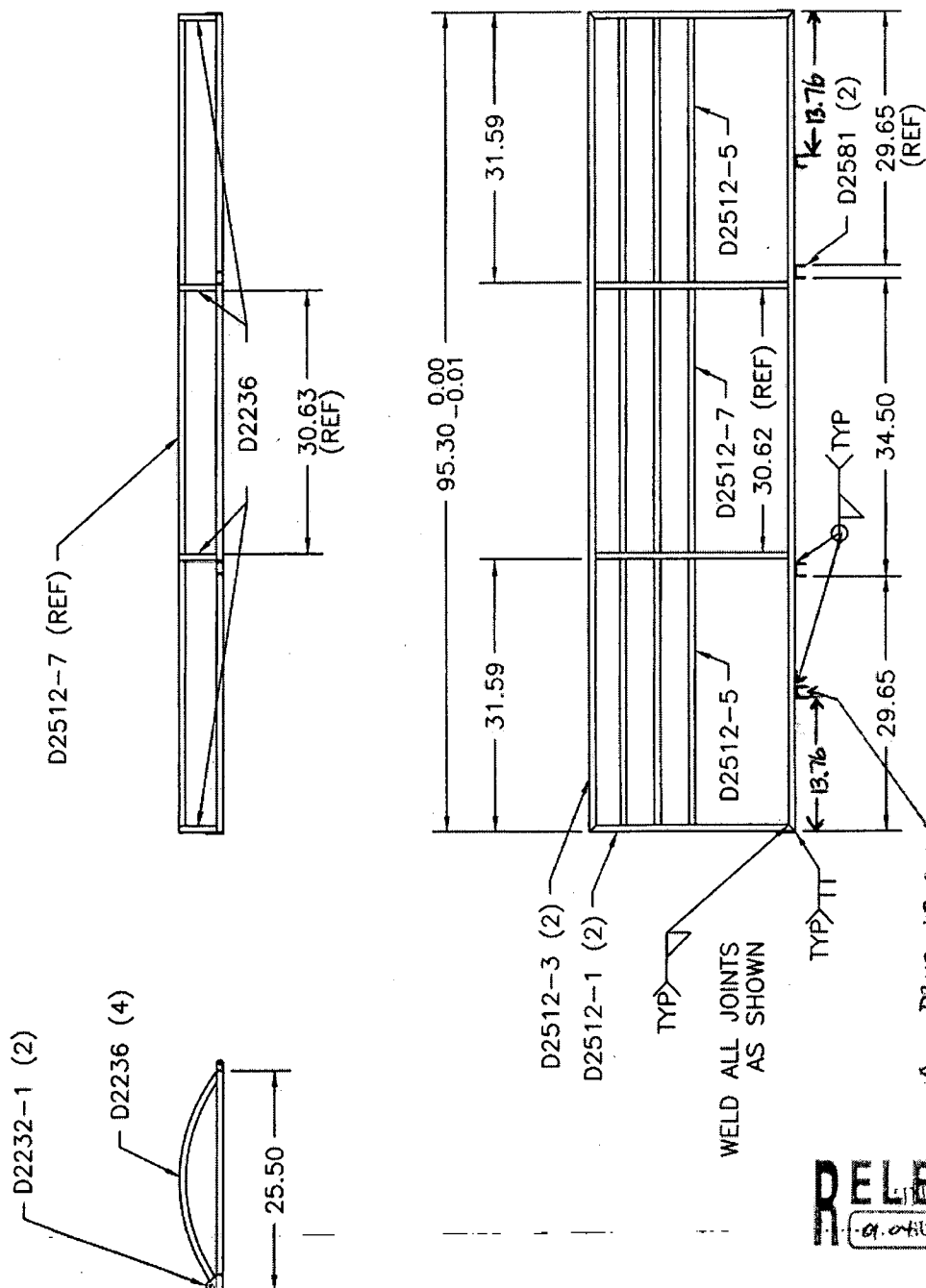
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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CHECKED H	APPROVED H	DRAWING NO. D2512	REV. D SHEET 3 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:20



plates)

DETAIL B

FRAMEWORK SHOWN FOR CLARITY

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

D2012-117 CLEMS
ADD FOR D130-701-041
ONLY (2 PLACES)

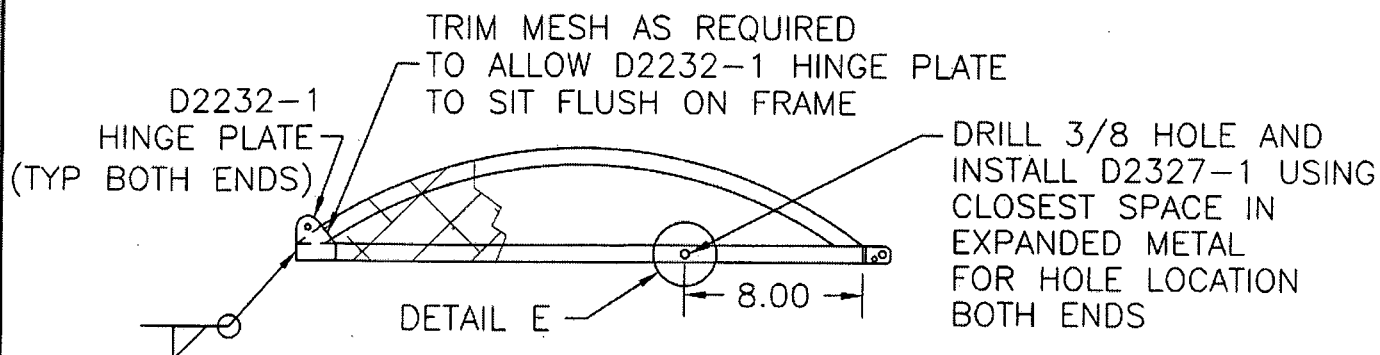
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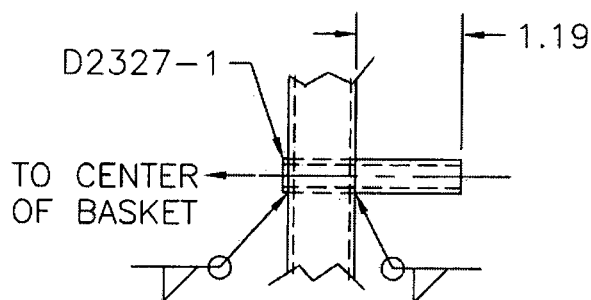
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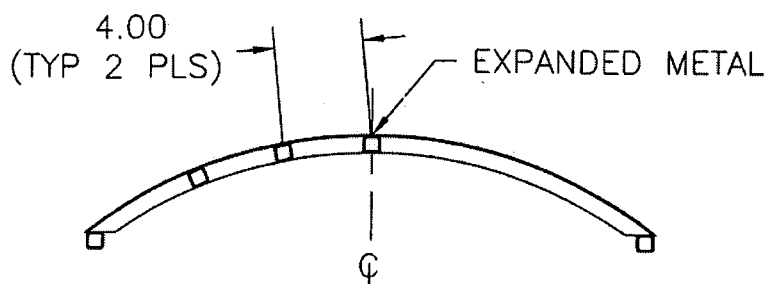
DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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